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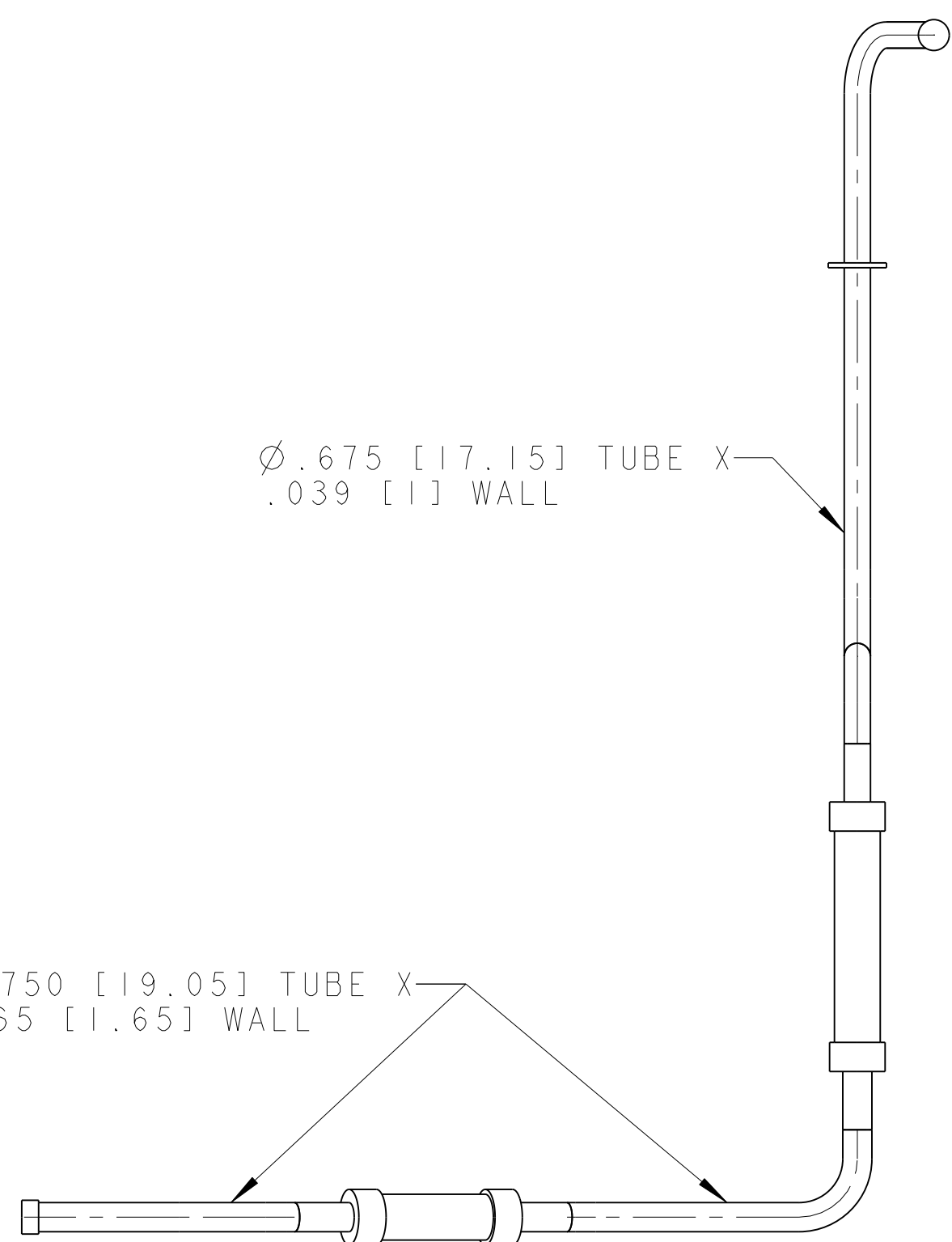
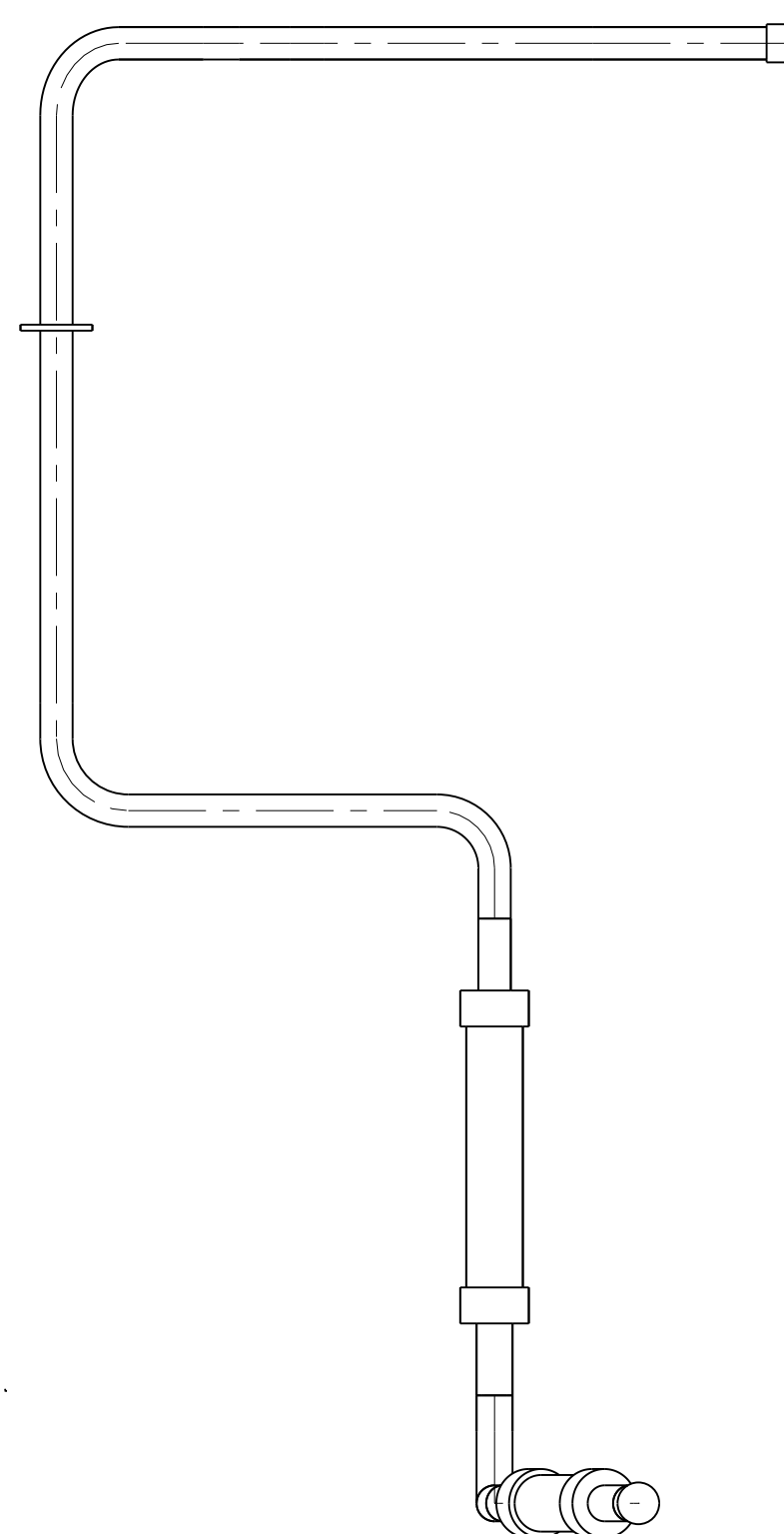
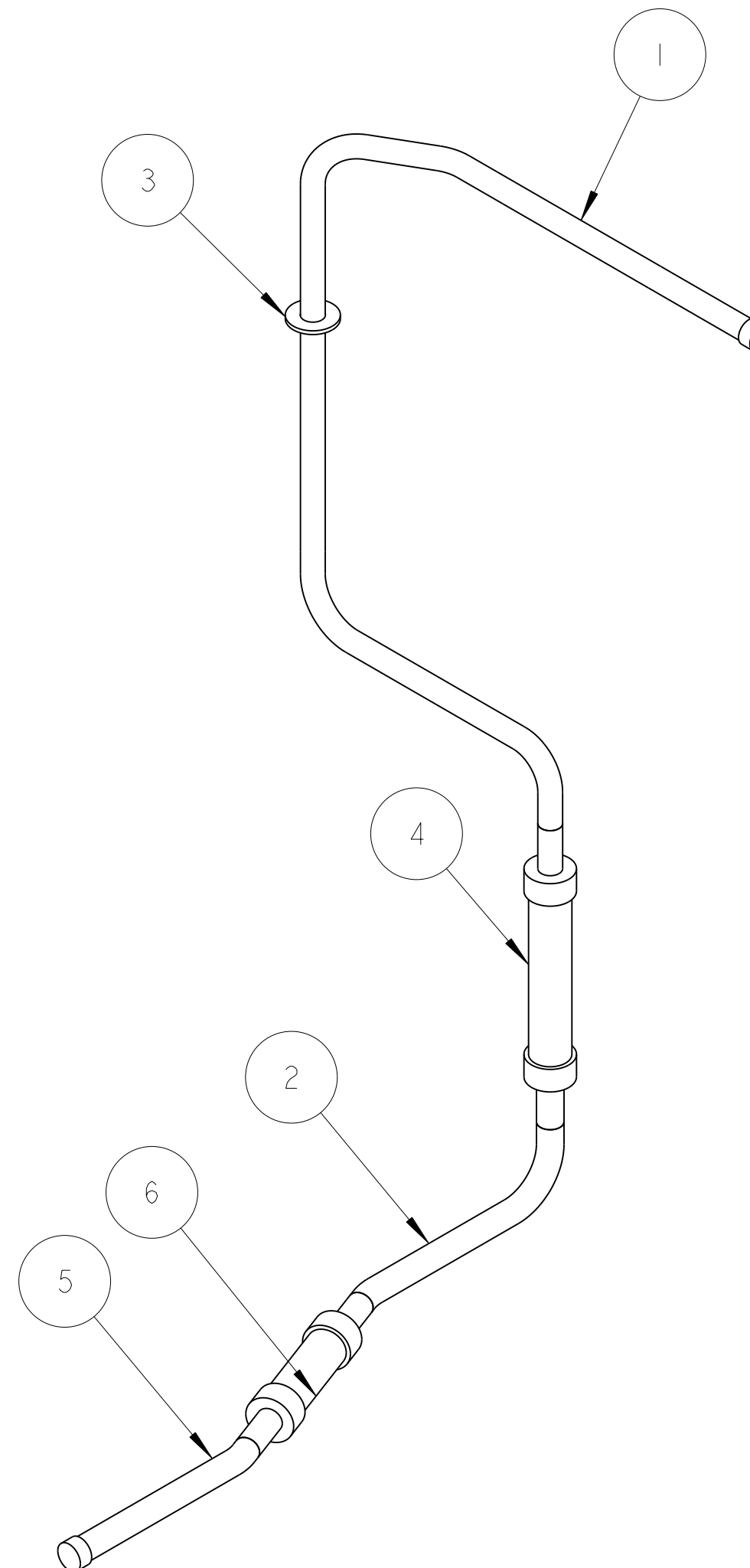
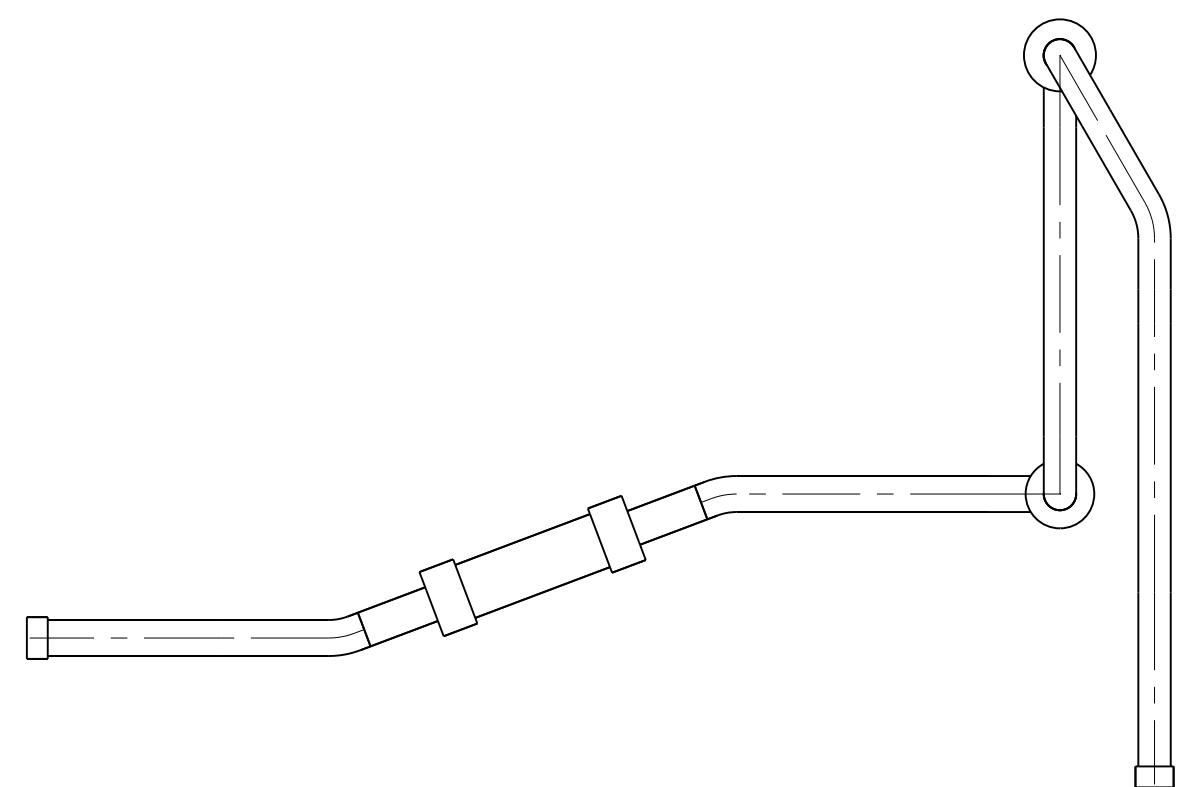
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DWG. NO. 2515034 SIZE REV. SH. A 1

NOTES: (UNLESS OTHERWISE SPECIFIED)

- THIS IS A CRYOGENIC VACUUM COMPONENT.
- WELDING PROCEDURE: PER VENDOR SPECIFICATION WITH LBNL APPROVAL.
- CLEANING PROCEDURE : PER VENDOR SPECIFICATION WITH LBNL APPROVAL.
- PACKAGING AND STORAGE PROCEDURE OF THE COMPONENTS: PER VENDOR SPECIFICATION WITH LBNL APPROVAL.
- DIMENSIONS AND TOLERANCING PER ANSI Y14.5M-1982. UNITS ARE IN INCHES [mm] UNLESS OTHERWISE SPECIFIED.
- USE OF SULFUR OR SILICONE BEARING OILS, LUBRICANTS, OR COOLANTS ARE STRICTLY PROHIBITED.
- USE OF RESIN OR RUBBER BONDED ABRASIVES UNDER POWER IS STRICTLY PROHIBITED. USE VITREOUS BONDED ABRASIVES ONLY.
- VENDOR SUGGESTED CHANGES TO WELD PREPS; SUBJECT TO LBNL APPROVAL.
- FITTINGS MAY BE USED IN PLACE OF BENDS; SUBJECT TO LBNL APPROVAL.

ITEM	PART NO	RECD	DESCRIPTION	MATERIAL
6	-	-	BRAIDED FLEX HOSE, 3/4" ID X 3" LL	SS 300 SERIES
5	-	-	TUBE, PER ASTM A269	SS 304L
4	-	-	BRAIDED FLEX HOSE, 3/4" ID X 5.4" LL	SS 300 SERIES
3	-	-	COLLAR	SS 304L
2	-	-	TUBE, PER ASTM A269	SS 304L
1	-	-	TUBE, PER ASTM A269	SS 304L

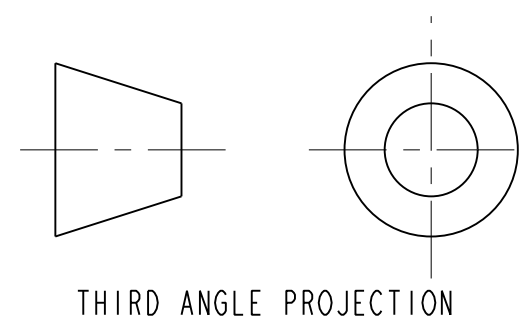


Ø.675 [17.15] TUBE X .039 [1] WALL

Ø.750 [19.05] TUBE X .065 [1.65] WALL

SCALE 1/4

- VENDOR SUGGESTED CHANGES TO TOLERANCES TO FACILITATE FABRICATION OR ASSEMBLY; SUBJECT TO LBNL APPROVAL.
- REMOVE ALL THE BURRS AND REAM THE ENDS FOR CIRCULARITY AND CLEAN ENDS.
- TUBE END SURFACE MUST BE PERPENDICULAR TO THE TUBE AXIS WITHIN +/- .010.
- PERFORM ACCEPTANCE TESTS PER SECTION 3.2 OF LBNL SPECIFICATION M856.
- A MARK DESIGNATING THE INSTALLED LENGTH WILL BE UTILIZED DURING FINAL INSTALLATION OF THE FEEDBOX ASSEMBLY. MARK, SCRIBE OR ETCH THIS LOCATION IN A PERMANENT MANNER, SUBJECT TO LBNL APPROVAL, TO AN ACCURACY OF ±0.063".
- PROVIDE A MINIMUM LENGTH OF 4.0" OF STRAIGHT, SMOOTH PIPE ON THE INDICATED SIDE OF THE INSTALLED LENGTH MARK FOR PIPE WELDING DURING FINAL INSTALLATION OF THE FEEDBOX ASSEMBLY.
- PIPE MUST BE STRAIGHT AND SMOOTH (NO BUMPS) FOR 0.5" ON EITHER SIDE OF THE CENTER-PLANE OF THE SUPPORT.
- CAP BOTH ENDS OF PIPE AFTER ACCEPTANCE TESTS PER SECTION 3.2 OF LBNL SPECIFICATION M856.



THIRD ANGLE PROJECTION

TOLERANCES		UNLESS OTHERWISE SPECIFIED		SHOP ORDERS		SER. NO. DATE ISSD		ERNEST ORLANDO LAWRENCE BERKELEY NATIONAL LABORATORY UNIVERSITY OF CALIFORNIA - BERKELEY	
X.X ± 0.1	FRAC. ± 1/64	ACCT. NO. Y	NO. RECD. Y	DEL. TO. Y	DATE RECD.	LHC IR FEEDBOX CRYOGENICS PIPE, EI		MICROFILMED: DWG. TYPE SHOWN ON SCALE: 1/4 DO NOT SCALE PRINTS	
X.XX ± 0.03	Angles ± 1.00°	DO NOT SCALE PRINT		PROJECT TAG		PROJECT N/A		DESIGN ACCT. NO. CATEGORY CODE	
X.XXX ± 0.010	FINISH 125 \sqrt{Ra}	THREADS ARE CLASS 2		METHOD N/A		PROJECT N/A		PATENT CLEAR: Z5LCE2 LH2003	
CHAMFER ENDS OF ALL SCREW THREADS 30°		CUT ROUND, 1.5 THREAD RELIEF ON MACHINED THREADS		DWG. BY: R. LA MANTIA DATE: 05-Apr-02		PROJECT N/A		DWG. NO. 2515034	
BREAK EDGES .016 MAX. ON MACHINED WORK		REMOVE BURRS, WELD SPLATTER & LOOSE SCALE		CHK. BY: S. VIROSTEK DATE: 25-Oct-02		PROJECT N/A		SIZE REV. A	
IN ACCORDANCE WITH ASME Y14.5M & B46.1		APPR. BY: D. OSHATZ DATE: 25-Oct-02		PROJECT N/A		PROJECT N/A		FILE: 2515034.PLT	

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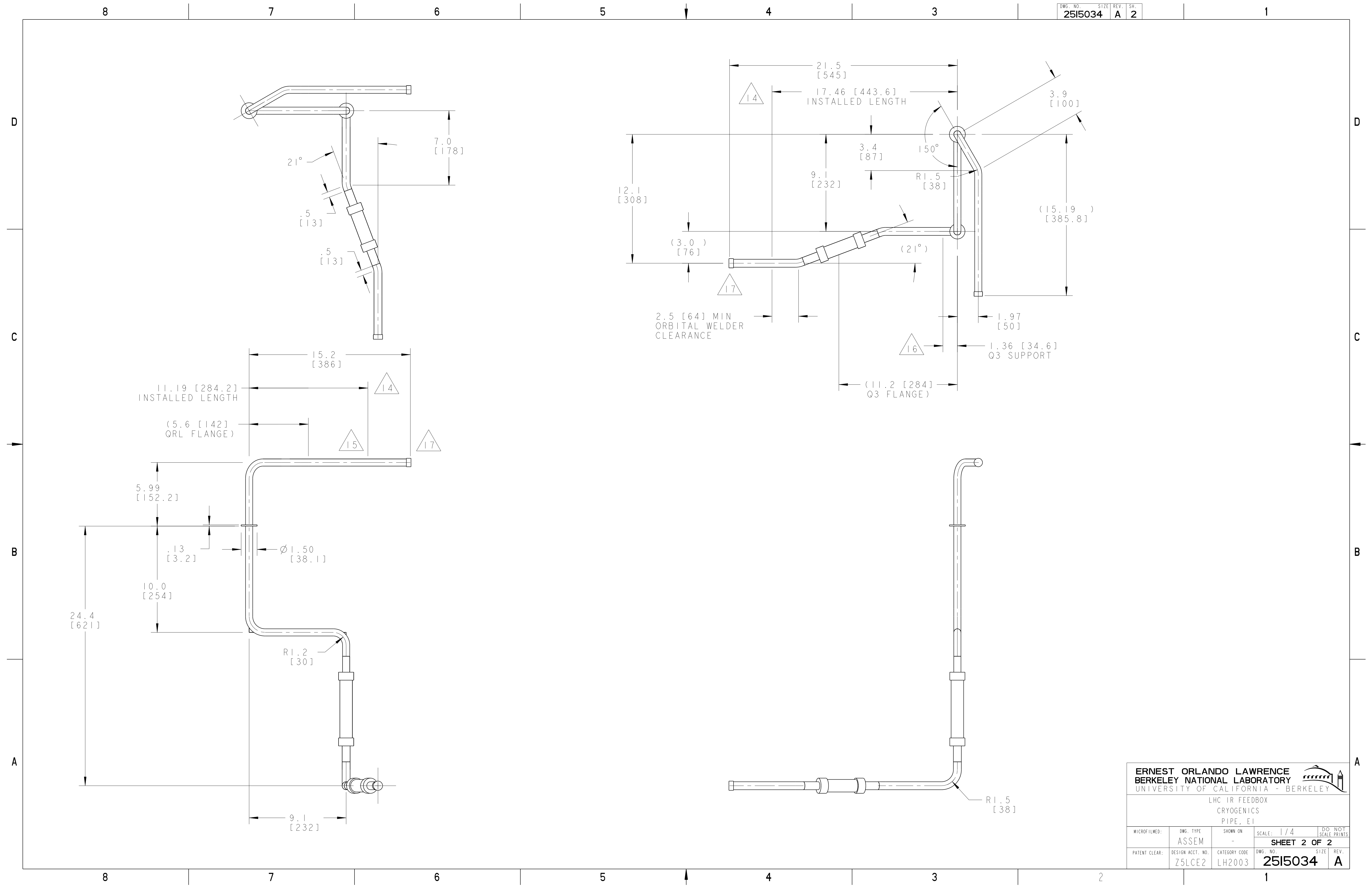
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ERNEST ORLANDO LAWRENCE
 BERKELEY NATIONAL LABORATORY
 UNIVERSITY OF CALIFORNIA - BERKELEY

LHC IR FEEDBOX
 CRYOGENICS
 PIPE, EI

MICROFILMED:	DWG. TYPE ASSEM	SHOWN ON -	SCALE: 1/4	DO NOT SCALE PRINTS
PATENT CLEAR:	DESIGN ACCT. NO. Z5LCE2	CATEGORY CODE LH2003	SHEET 2 OF 2	
DWG. NO. 2515034			SIZE A	REV. A